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## IN THE SPECIFICATION:

Please replace the paragraph commencing on page 3 with the text "In accordance with a first embodiment of the present invention ..." with the following replacement paragraph:

-- In accordance with a first embodiment of the present invention, there is provided an order merging system, the system comprising: ~~a pair of first case guides having a pair of twisted lanes, the first case guides being downwardly sloped for guiding at least one product case therealong in each of the first case guides; a pair of raisable guides connected downstream of the first case guides and in communication therewith; a pair of second case guides in communication with the raisable guides, the raisable guides being lowered to allow the product cases~~ at least two depalletizing stations, each depalletizing station being dedicated to a different respective product unit depalletized thereon; for each depalletizing station, at least one pair of first case guides in communication therewith and having at least one pair of twisted lanes, the first case guides being downwardly sloped for guiding at least one product case of the respective product unit for the depalletizing station therealong in each of the first case guides; for each pair of first case guides, at least one pair of raisable guides connected downstream thereof of the first case guides and in communication therewith; at least one pair of second case guides in communication with the raisable guides, the raisable guides being lowered to allow the product cases of the respective product unit for the depalletizing station from the first case guides to merge onto the second case guides. --

Please replace the paragraph commencing on page 8 with the text "Due to a high rate of instantaneous demand ..." with the following replacement paragraph:

-- Due to a high rate of instantaneous demand which is required for an individual SKU, compared to the rate at which the operator 41 can depalletize, the sloped gravity conveyor 62 acts as a buffer to ensure that the system 10 does not run out of product. The sloped gravity conveyor 62 is a steep, twisted, high-speed controlled gravity accumulation conveyor in which cases of product traveling from the hingeable conveyor 55 to the mixing conveyor 16 pass through two accumulating gravity curves 74, 76 located in the parallel

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accumulation lanes 66, 68. The sloped gravity curve 62 sloped downwardly towards the mixing conveyor 16, which is planar. Although two gravity curves 74, 76 are illustrated, one skilled in the art will understand that although two gravity curves 74, 76 are illustrated, the upper gravity curve 74 can be removed leaving only one gravity curve 76 located at the lower end of the sloped gravity conveyor 62, without deviating from the scope of the present invention. The travel speed of the cases of product 40 is limited by series of speed controllers 79 connected to the accumulation lanes 66, 68. A brake/ metering mechanism 78 is integrated into each of the parallel lanes 66, 68 and includes an actuatable friction pad 69, which applies friction to the underside of the rollers of the accumulation lanes 66, 68 to stop them from rolling. Boxes, which may be travelling down the sloped conveyor 62, will stop on the stopped rollers. The brake mechanism holds back accumulating product and meters the product into a merging area 80 when the brake mechanism is released. The curve 76 leads the boxes towards a downstream stopper mechanism 82, which ensures that no boxes pass therethrough onto a movable chute 84 when they are not expected and thereby acts as a safety device. The chute 84 is lowered just in time to allow the box to merge onto the mixing conveyor 16. The movable chute 84, as illustrated, operates as a pair of raisable guides, which lower guide, which lowers to allow the boxes to merge onto the mixing conveyor 16. --